

Work Order ID 106002

106002

Page 1

August-28-13 12:27:08 PM

Item ID: D4148-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Lug Plate. Fwd

Stop

NS2

Start Date: 8/28/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/28/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 13-08-29

Tooling: _____ Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D4148	E								
-------	---	--	--	--	--	--	--	--	--

100 0.00

100

Waterjet

Memo

0.00

14 0 Jm3-09-5

FLOW CNC Waterjet

Cut as per dwg D4148

Prog Rev: E

Dwg Rev: E

Deburr as required

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.00

14 0 Jm3-09-5

Quality Control

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
														<input type="checkbox"/> Other	

Work Order ID 106002

106002

Page 2

August-28-13 12:27:08 PM

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Setup

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Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC	QC8- Inspect parts - second check	0.00	DAS 27	9-89		14			
Quality Control	Memo	0.00			13.9.6				
150 *150* Packaging	Identify as per dwg & Stock Location: <u>ST145</u>	0.00				14X	28	13-09-6	
Packaging	Memo	0.00							
160 *160* QC	QC21- Final Inspection - Work Order Release	0.00							13/9/13
Quality Control	Memo	0.00							

13-09-6

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>						
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>						
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												
FAULT CATEGORY												
Landing Gear	General											
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>							
	Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
	Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>							
	Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>								
	Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
	Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>							
	Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>									
	Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									
	Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>									

Picklist Print

August-28-13 12:27:08 PM

Page 1

Work Order ID: 106002
Parent Item: D4148-1
Parent Item Name: Crosstube Lug Plate. Fwd
Start Date: 8/28/13 Required Date: 8/28/13
Start Qty: 12.00 Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.10.29 as per revC DD verf:EC
DWG REV.D DD VERF:EC IPP REV:C 11.03.02 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	285.6933	0.3607	45562104 5.0			Jan 13-09-5

Location	Loc Qty	Loc Code
MAT020	285.6932632	
122521	19.1432632	
I24445	92.54	124445
M126075	174.01	126

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>				Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>		Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>		Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>		Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>	
Root Cause	Date	Step	Qty.	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Other											

DART AEROSPACE LTD		Work Order:	106002
Description: Fwd Crosstube Lug Plate		Part Number:	D4148-1
Inspection Dwg: D4148	Rev: D		Page 1 of 1

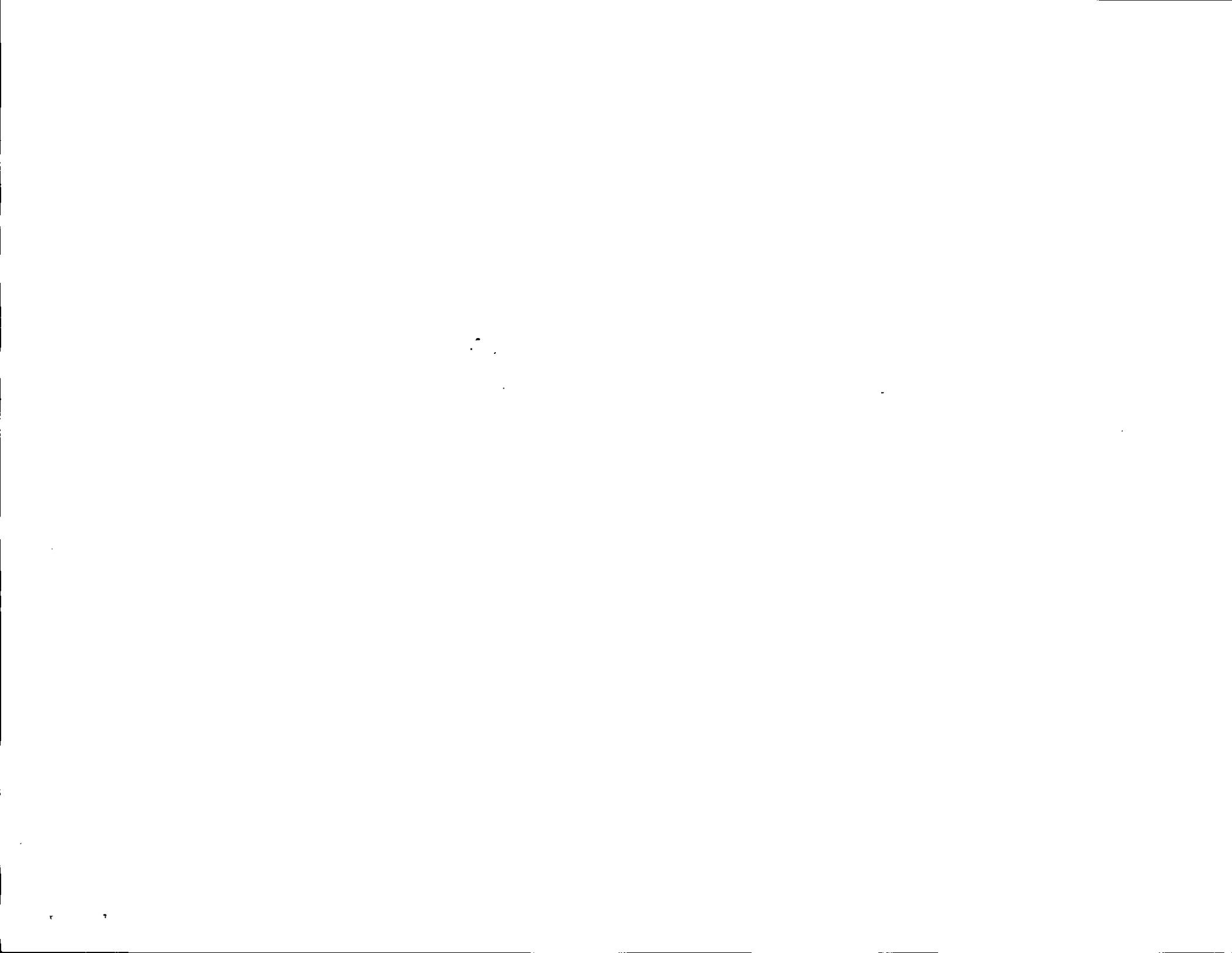
FIRST ARTICLE INSPECTION CHECKLIST

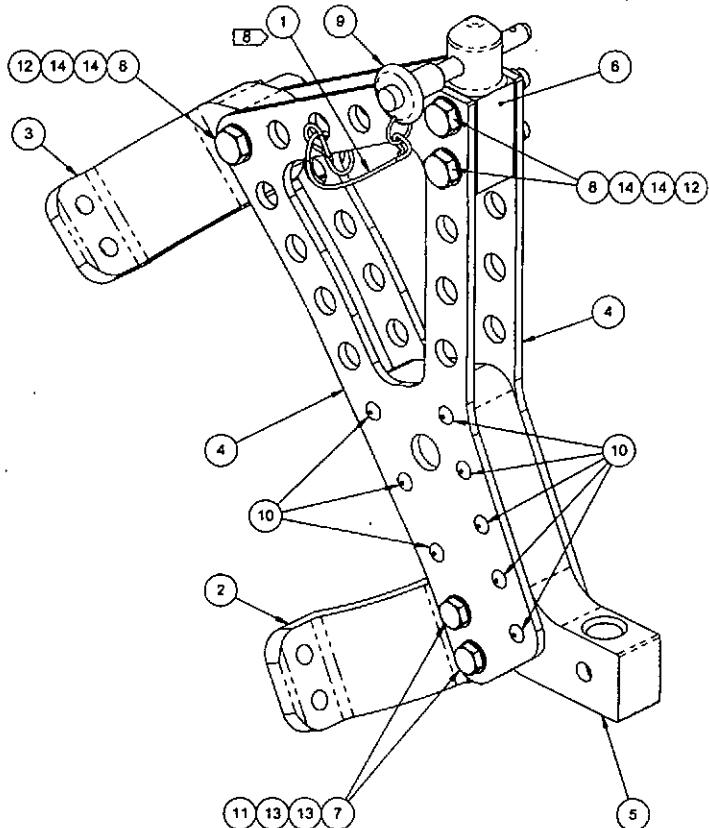
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130"	—		U	JLmo1
Ø0.191	+0.005/-0.001	0.193"	—		U	
Ø0.38	+0.006/-0.001	0.375"	—		U	
Ø0.257	+0.006/-0.001	0.259"	—		U	
Ø0.50	+0.006/-0.001	0.497"	—		U	
0.94	+/-0.030	0.94"	—		U	
4.47	+/-0.030	4.474"	—		U	
0.750	+/-0.010	0.753"	—		U	
8.47	+/-0.030	8.47"	—		U	Production
8.096	+/-0.010	8.096"	—		U	
5.43	+/-0.030	5.43"	—		U	
5.197	+/-0.010	5.197"	—		U	
4.733	+/-0.010	4.733"	—		U	
0.310	+/-0.010	0.315"	—		U	
0.750	+/-0.010	0.752"	—		U	
0.375	+/-0.010	0.378"	—		U	
1.84	+/-0.030	1.843"	—		U	
0.92	+/-0.030	0.917"	—		U	
3.000	+/-0.010	3.003"	—		U	
0.750	+/-0.010	0.747"	—		U	
0.625	+/-0.010	0.623"	—		U	
1.982	+/-0.010	1.983"	—		U	
0.991	+/-0.010	0.997"	—		U	
0.77	+/-0.030	0.765"	—		U	
1.54	+/-0.030	1.54"	—		U	
2.47	+/-0.030	2.47"	—		U	
0.82	+/-0.030	0.82"	—		U	
3.57	+/-0.030	3.57"	—		U	
1.23	+/-0.030	1.23"	—		U	
0.73	+/-0.030	0.730"	—		U	
0.125	+/-0.010	0.116"	—		U	
Ø0.252	+0.003/-0.000	0.254"	—		U	

DAS 9-89

Measured by:	jm	Audited by:	27 9-89	Preliminary Approval:	
Date:	13-09-5	Date:	13-9-6	Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	





D4148-041 FWD X-TUBE LUG ASSY

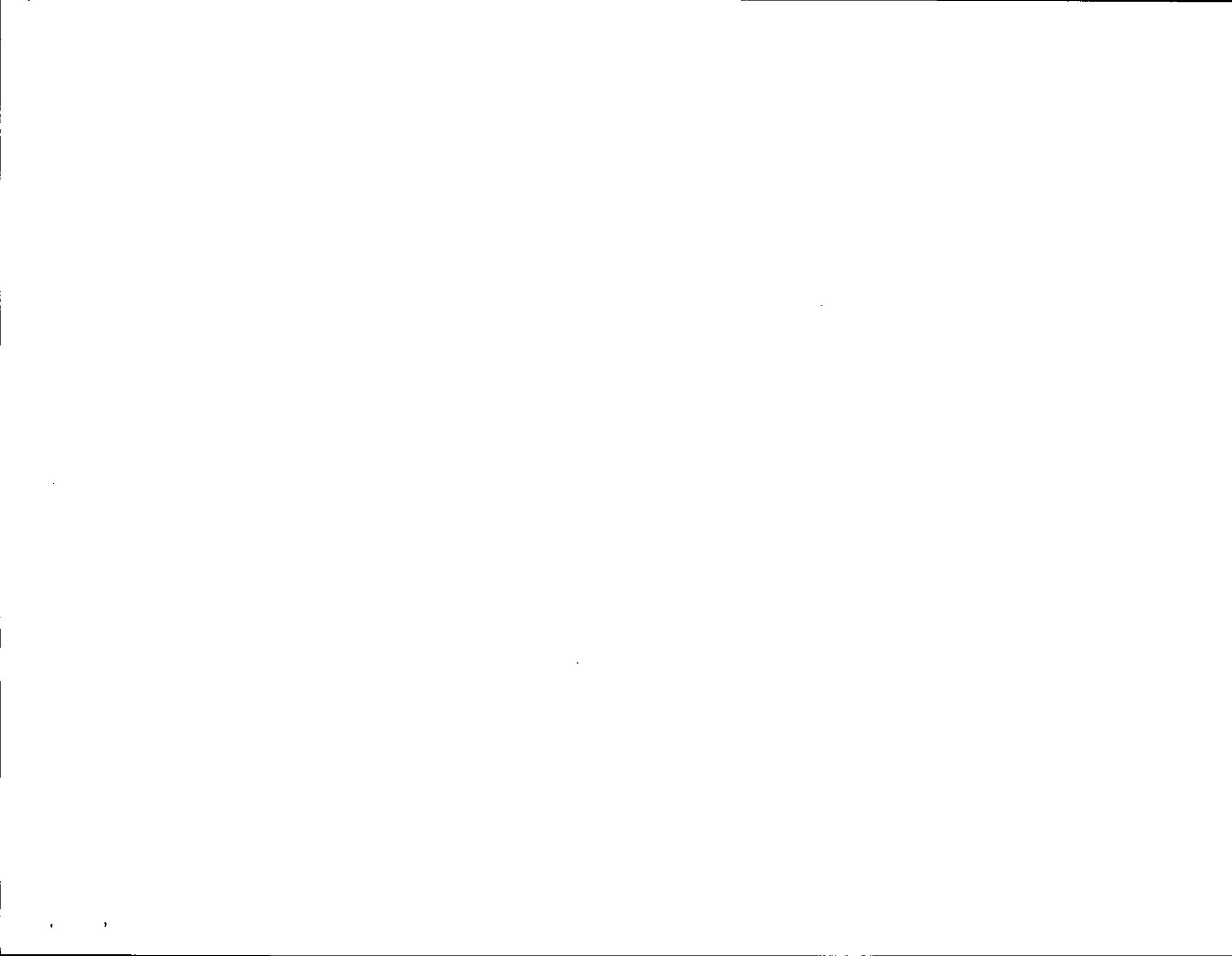
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018
4) UNITS: INCHES UNLESS OTHERWISE
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH
7) WEIGHT: 3.66 lbs
8) ATTACH D2690-6 TO D4148-1 BY L

ITEM	QTY	P/N	DESCRIPTION
	1	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIN, QUICK RELEASE
10	8	MS20815-4M18	RIVET, SOLID, PAN-HEAD
11	2	MS21043C3	NUT, SELF-LOCKING
12	3	MS21043C4	NUT, SELF-LOCKING
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

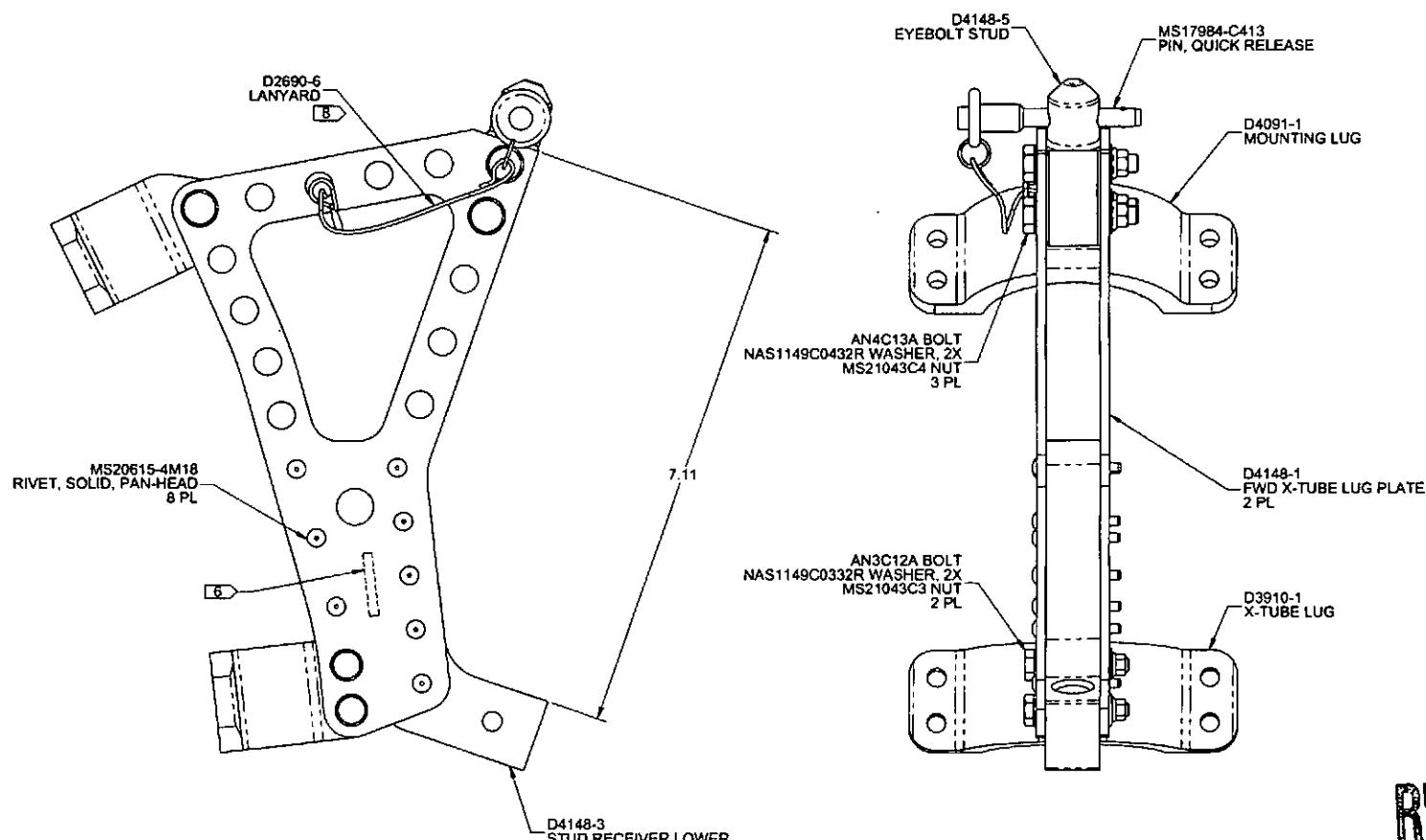
106002 MCJ
13-08-29

RELEASED
2013-08-16 15:00

E	B6-4 Ø0.286 HOLE ADDED FOR CARGO TUBE INSTALLATIONS.	AJS	13.07.22
D	HOLE DIA CHANGED TO D .252" (D6-3). HOLE DIA CHANGED TO Ø.250" (CB-5). REPLACED QTY(2) AN3C12A, M521403C3 AND QTY(4) NAS149C0332R WITH QTY(2) AN3C13A, M521403C4 AND QTY(4) NAS149C0432R (D3-1.C4-2)	SC	11.02.22
C	REDESIGNED Q4146-1/2 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M16 WITH QTY(2) EACH AN3C12A, M521403C3 AND QTY(4) NAS149C0332R WASHER (2N D3-1 & B7-3). Ø.129 2 PL WAS 0.191 WAS MS20615-4M20 (2N D3-1 & B7-3). Ø.129 2 PL WAS 10 PL (2N A7-3); Ø.191 WAS 0.129 (2N CB-5). REASON: SEE TR-D350-597-2 REV B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.		D4148	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	
DATE	13.07.22		



106002

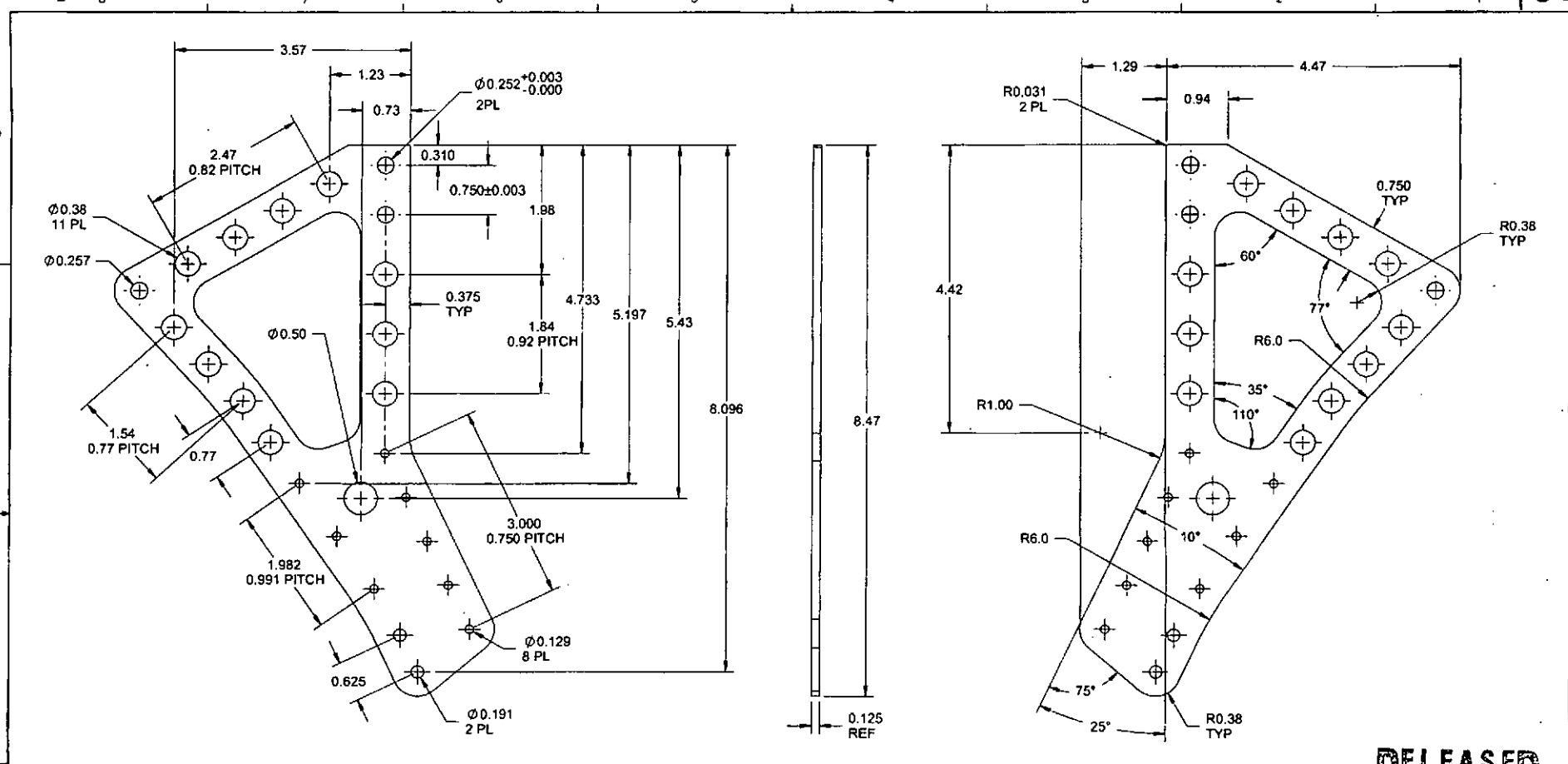


D4148-041 FWD X-TUBE LUG ASSY

DESIGN	MS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>WJ</i>	DRAWING NO. REV. E
MFG. APPR.	<i>WJ</i>	D4148 SHEET 2 OF 5
APPROVED	<i>WJ</i>	TITLE SCALE
DE APPR.	<i>WJ</i>	FWD X-TUBE LUG ASSY NTS
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106002



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

DESIGN	MB	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	DRAWING NO. REV. E
APPROVED	<i>[Signature]</i>	D4148 SHEET 3 OF 3
DE APPR.	<i>[Signature]</i>	TITLE SCALE
DATE	13.07.22	FWD X-TUBE LUG ASSY NTS

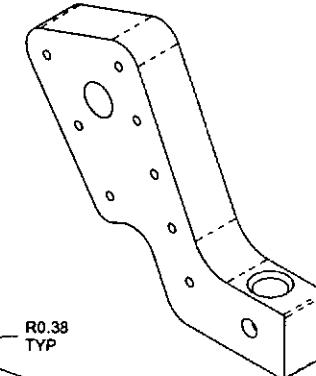
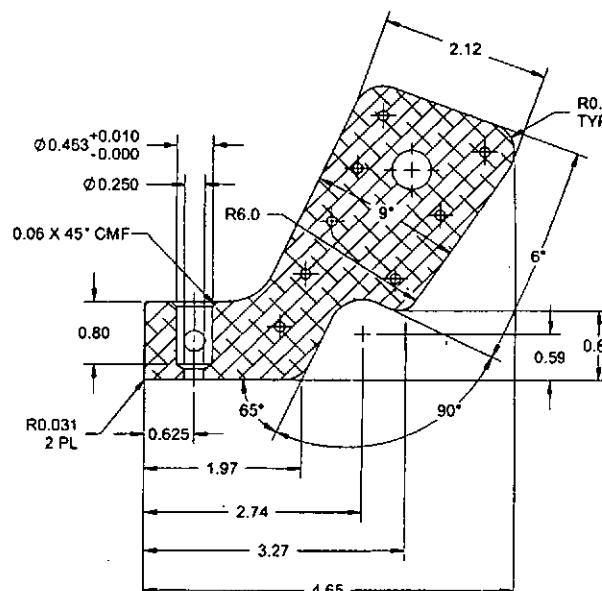
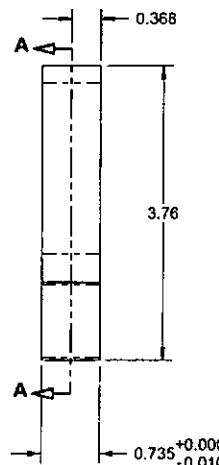
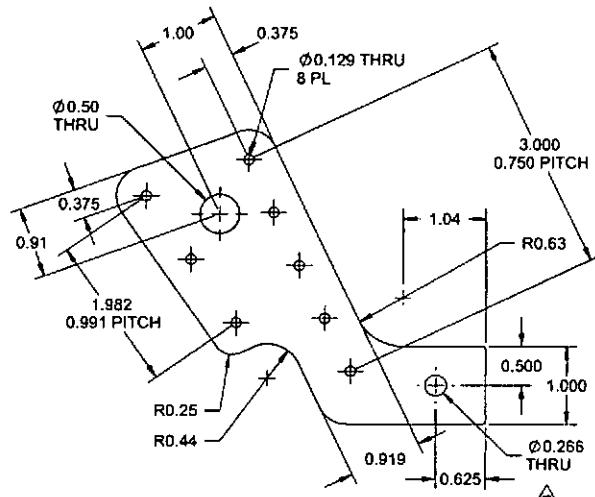
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RELEASED

2013-08-16

[Signature]

A A



D4148-3 STUD RECEIVER LOWER

SECTION A-A

RELEASED
2013-08-16

NOTES:

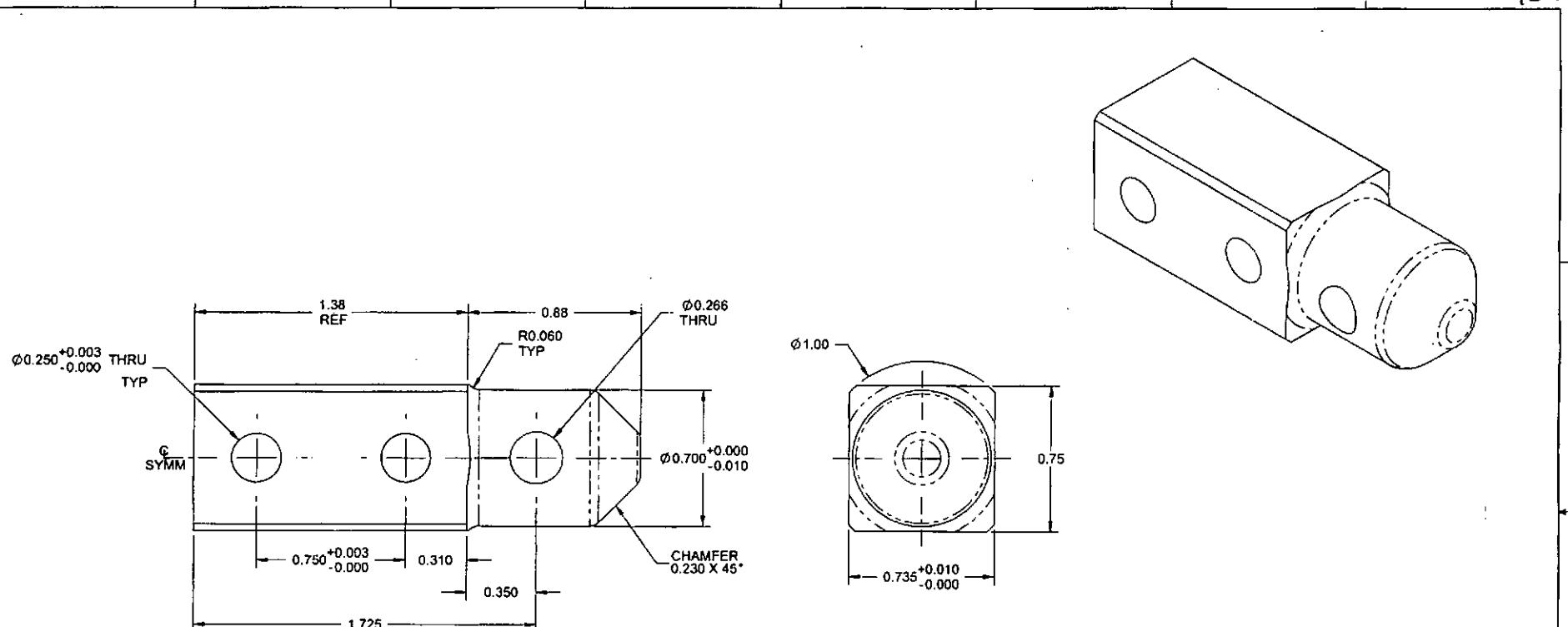
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.51 lbs

DESIGN	MB	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. E
APPROVED		D4148
DE APPR.		SHEET 4 OF 5
DATE	13.07.22	TITLE FWD X-TUBE LUG ASSY INTS

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106002



D4148-5 EYEBOLT STUD

RELEASE
2013-08-16
M

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SL</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>SL</i>	D4148	SHEET 5 OF 5
APPROVED	<i>AM</i>	TITLE	SCALE
DE APPR.	<i>SL</i>	FWD X-TUBE LUG ASSY	
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